

# Work Order ID 50480



Page 1

July 10, 2009 2:30:25 PM

Item ID: D3828-1KIV

Accept



Setup Start



Revision ID: A-PROTO

Item Name: Vertical Tunnel Lower, LH

Stop



Start Date: 07/13/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 07/17/2009 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: MF

Date: 09-07-10

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3828	A-PROTO 09.06.12

100 0.00



Hand Thermo

Memo

0.00

Hand Finishing Thermoforming

1-Cut Sheet to required Blank size

BB BB 09/07/14 X  
M100703

110 0.00



Thermoform

Memo

0.00

Thermoforming Machine

1. Machine Set-Up  
2. Pre-heat tool to required temp.  
3. Thermoform as per Dwg and Folio # FTA052 using tool DT9073  
Dwg Rev:   
Folio Rev:

BB BB 09/07/14 (X1)



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Item ID: D3828-1KIV

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Item Name: Vertical Tunnel Lower, LH

Start Date: 07/13/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 07/17/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

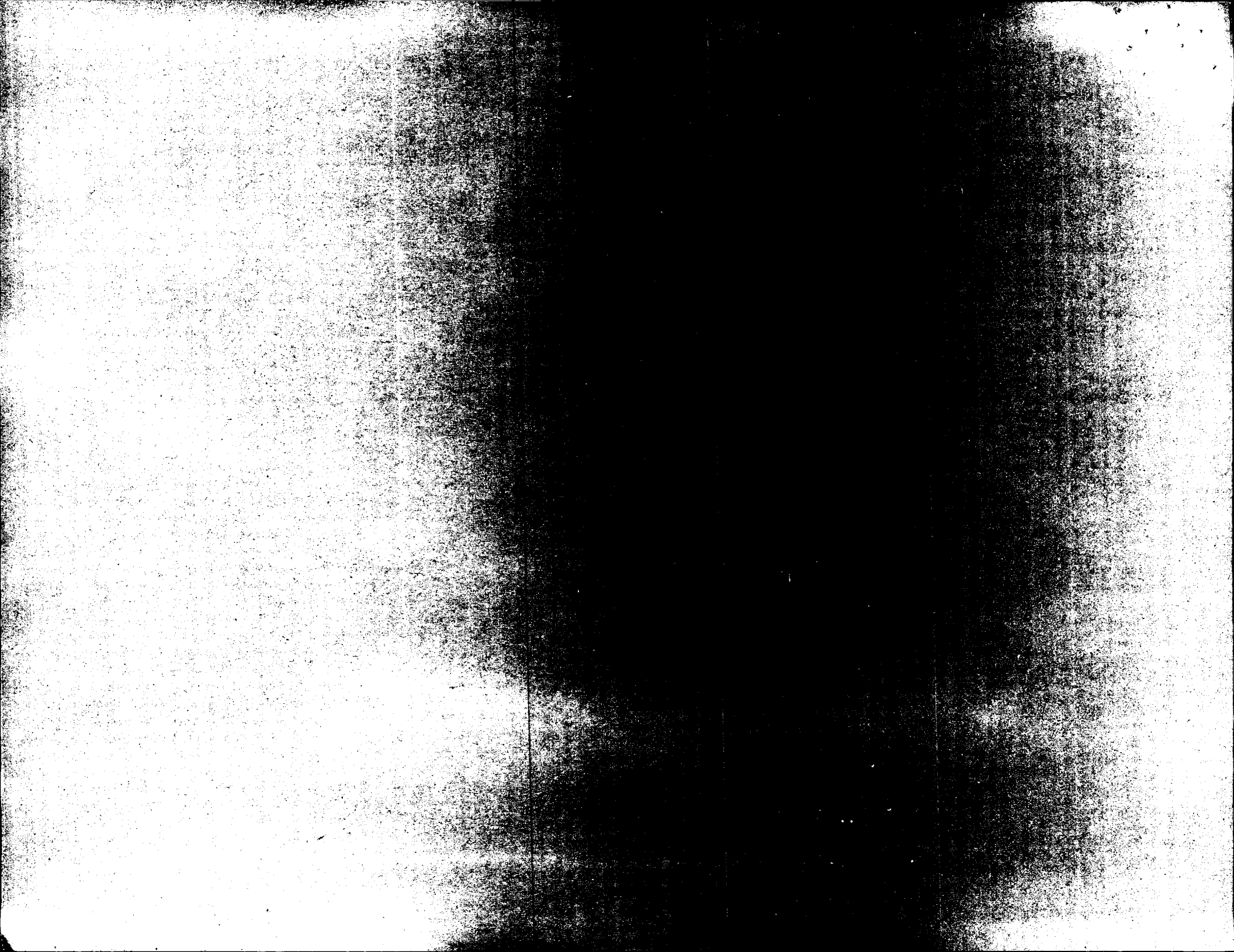


Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC Quality Control	Memo Visually inspect part for proper formation and texture	0.00							
130 	QC8- Inspect parts - second check	0.00							
QC Quality Control	Memo	0.00							
140 	Hand Finishing Thermoforming	0.00							
Hand Finishing Thermoforming	Memo Hand finished dimensions as per drawing	0.00							

BB 09/07/14 XI

DL 09/07/15 XI

DL 09/07/15 XI



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Item ID: D3828-1KIV

Accept

Setup Start

Revision ID: A-PROTO

Stop

Item Name: Vertical Tunnel Lower, LH

Start Date: 07/13/2009 Start Qty: 1.00

Cust Item ID:

Required Date: 07/17/2009 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

Complete FAI document

DL 09/02/15 (x1)

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

RF 09.07.20

ENGINEERING  
APPROVAL

170

Identify as per dwg & Stock Location

0.00



Packaging

Memo

0.00

Packaging

} FOR ENG TEST  
09-07-20 RF



APPROVAL  
ENGINEERING

**Work Order ID 50480**

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July 30, 2009 2:30:25 PM

Item ID: D3828-1KIV

Accept



Setup Start



Revision ID: A-PROTO

Stop



Item Name: Vertical Tunnel Lower, LH

Start Date: 07/13/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 07/17/2009 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

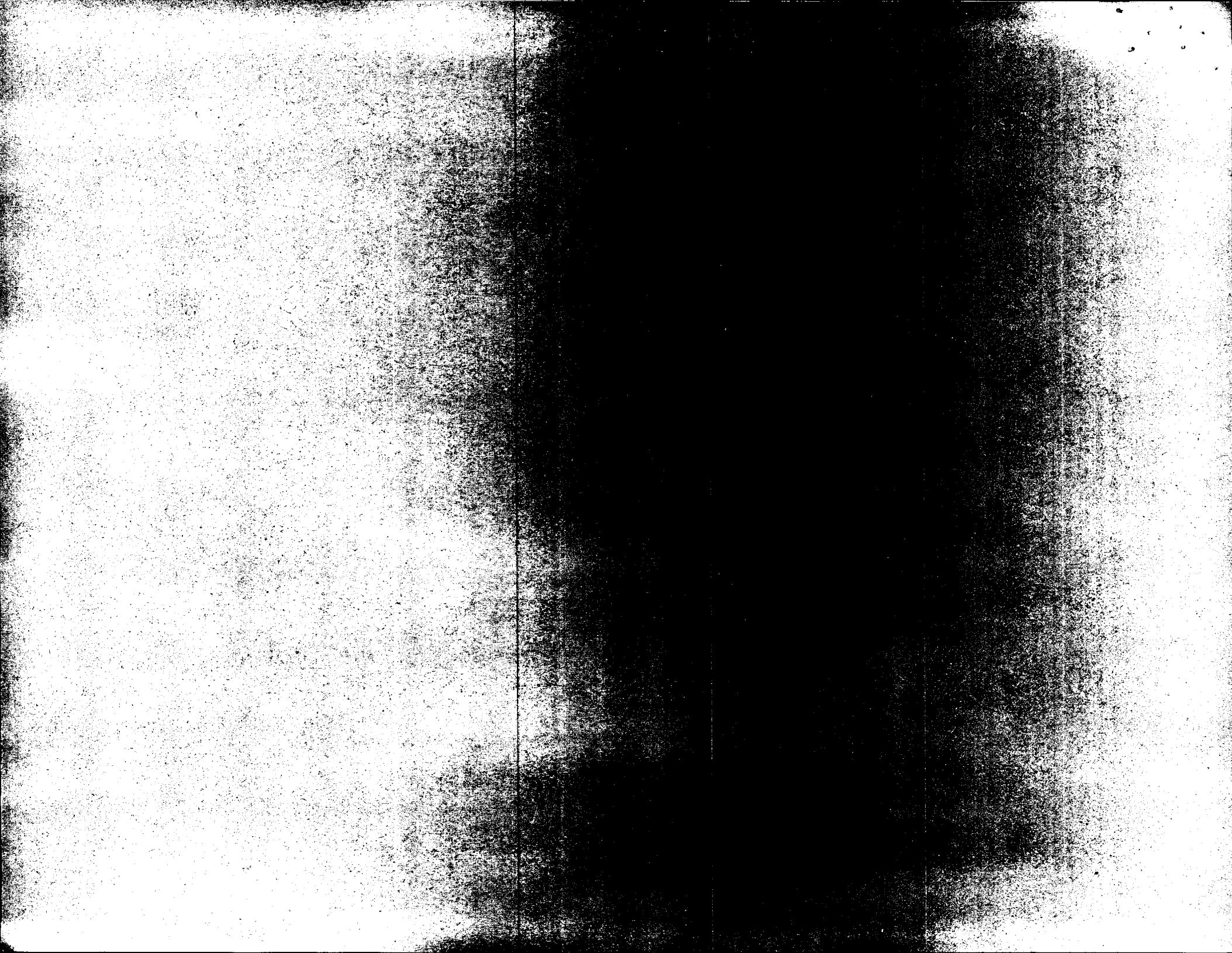
QC

Memo

0.00

Quality Control

*09.07.20 Prototype**24-0709*





**Picklist Print**

Page 1

July 10, 2009 2:30:25 PM

Work Order ID: 50480

Parent Item: D3828-1KIVRevA-PROTO

Parent Item Name: Vertical Tunnel Lower, LH

Start Date: 07/13/2009

Required Date: 07/17/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MKYD6185S.080-P3- 62015		Purchased	No			100	sf	894.5038	2.6250			



6185 KYDEX .080"

WarehouseLoc QtyLoc CodeLocation

Main Warehouse

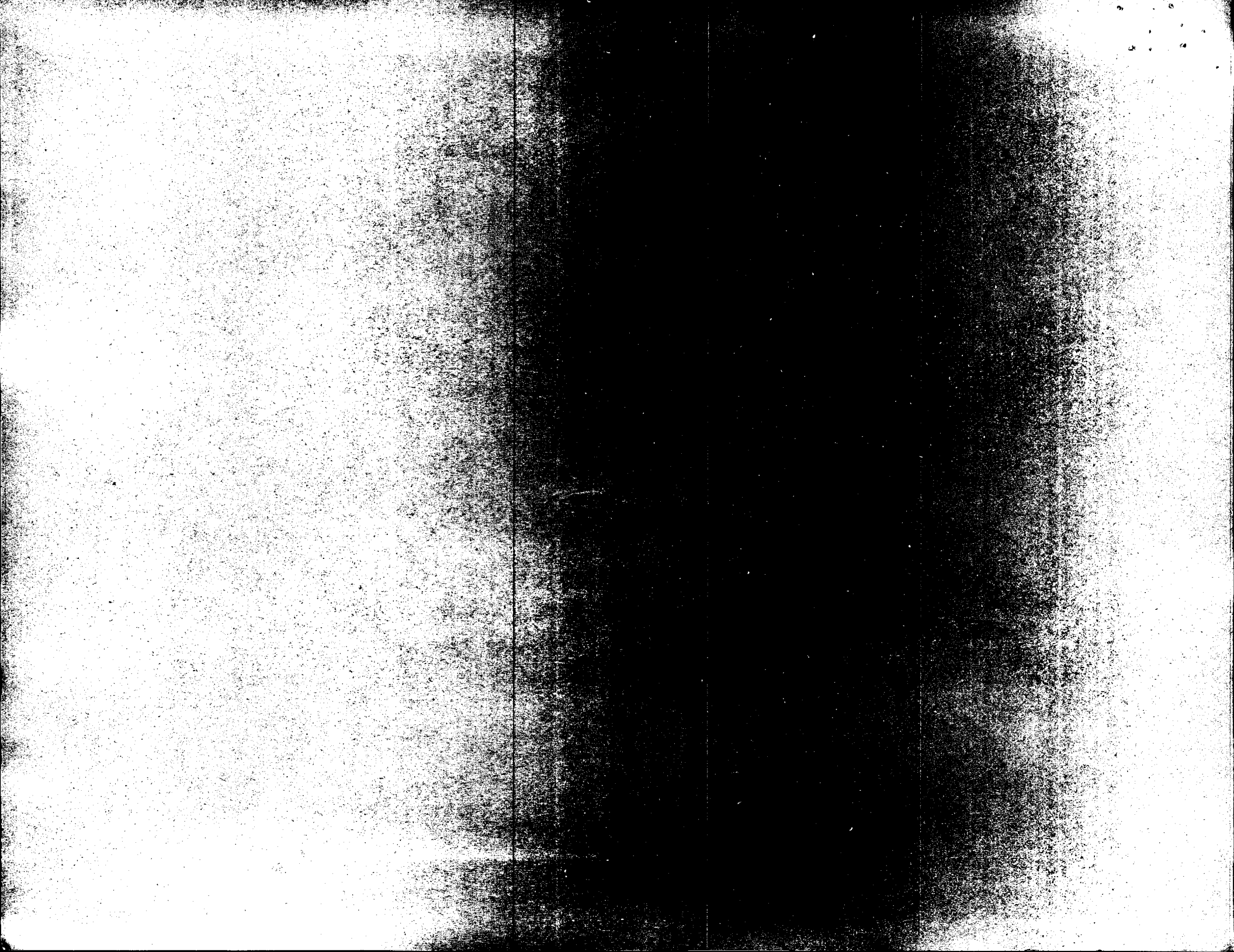
MAT

894.5037653

109703

894.503765

M109703 B 07/07/14



DART AEROSPACE LTD	Work Order: 50480
Description:	Part Number: D3828-1K12
Inspection Dwg: D3828-1 Rev: A PROTO	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

### THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than _____"	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: BB

Date: 09/07/16

### TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.5	$\pm .100$	4.5"	✓			
.5	$\pm .100$	0.564"	✓			
.9	$\pm .100$	.89"	✓			
0.090	$\pm .005$	0.097	✓			
1.0"	$\pm .100$	1.058"	✓			
0.090						

Measured by: Wheeler

Date: 09/07/15

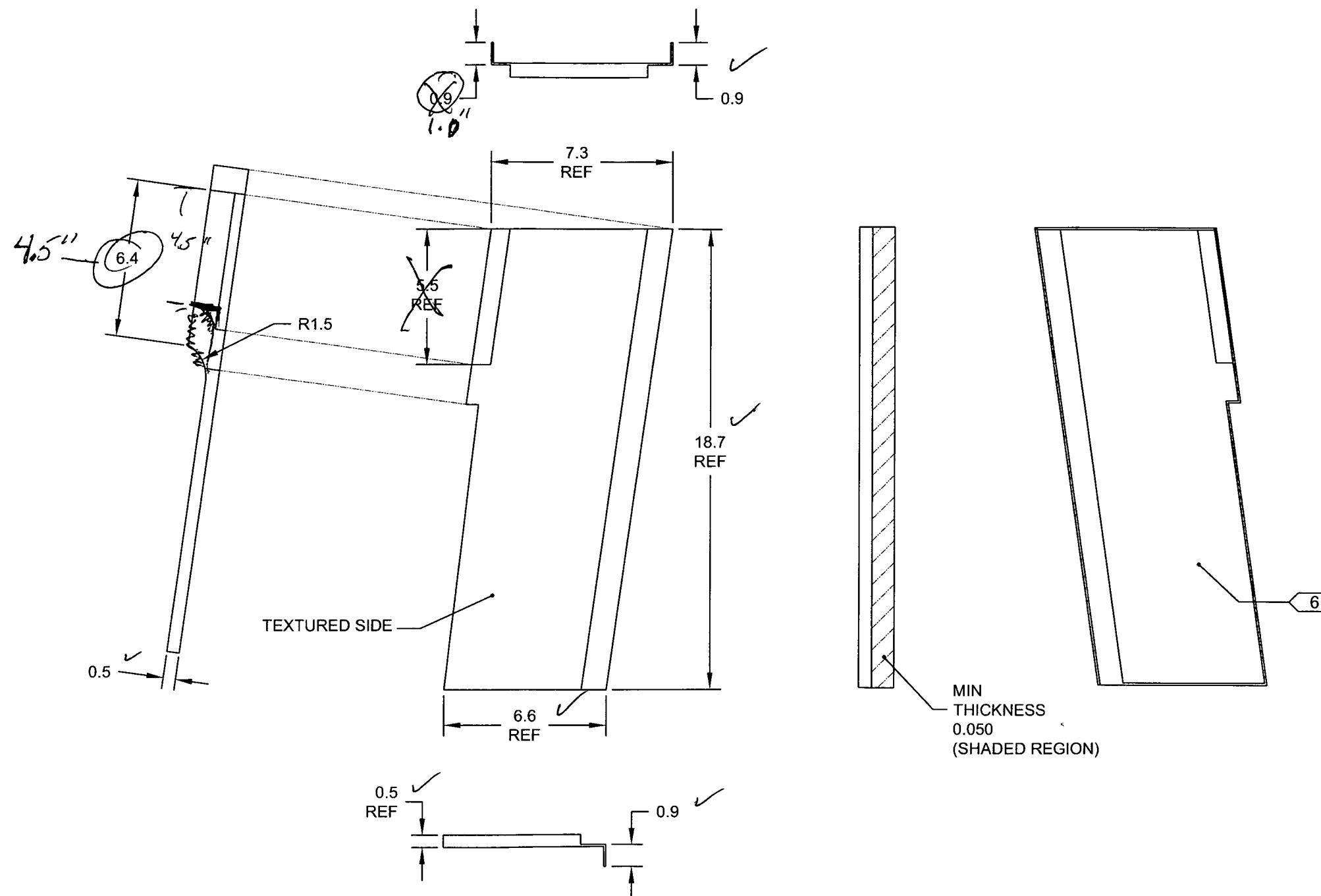
Audited by: RJ

Date: 09.07.17

Prototype Approval: RJ

Date: 09.07.17

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	



**PROTOTYPE**  
PLEASE RETURN ALL ISSUED  
DATA TO ENGINEERING  
09.07.07 AB

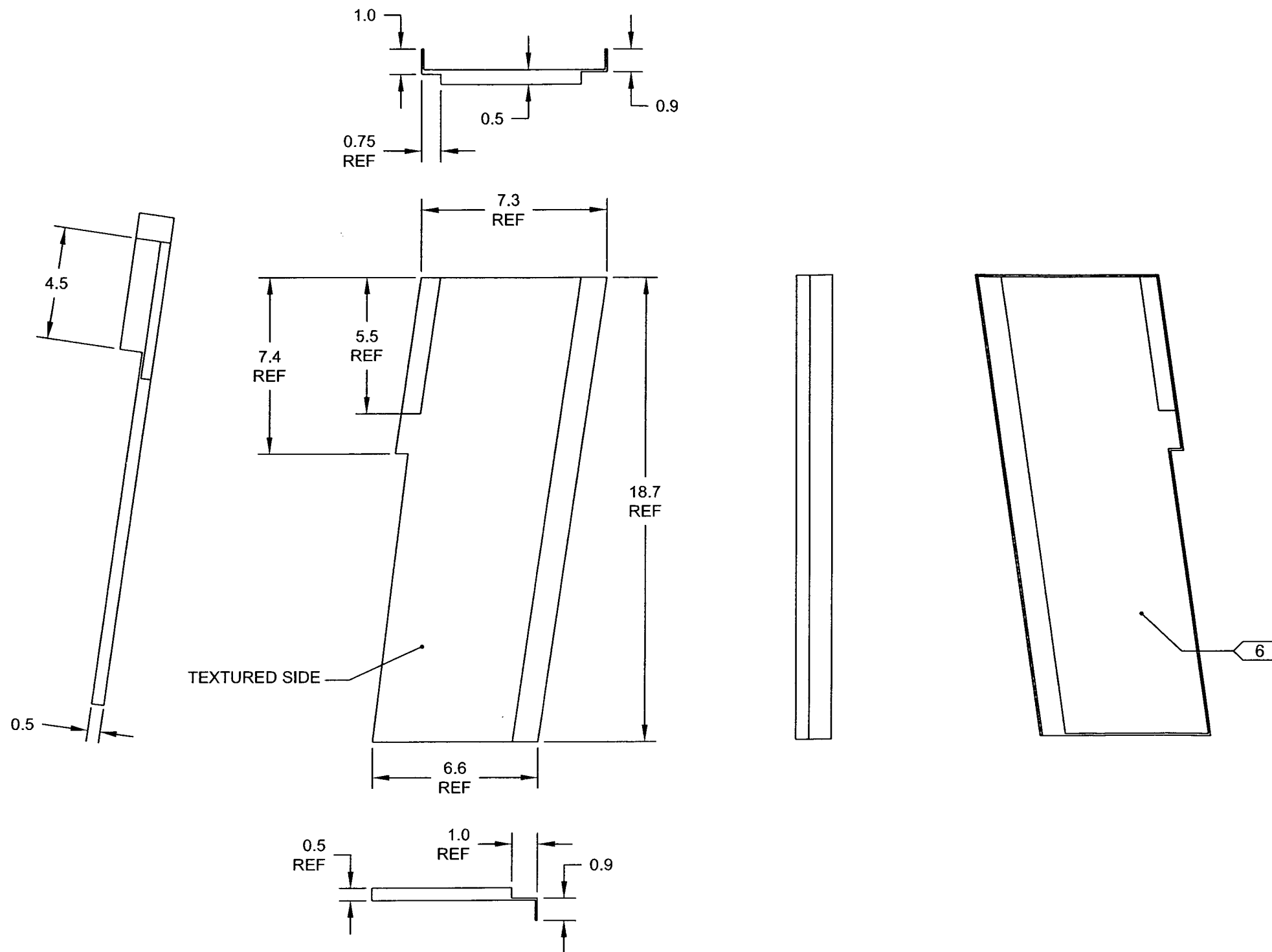
**D3828-1 VERTICAL TUNNEL, LOWER L/H**

- NOTES:**
- 1) MATERIAL: SEE TABLE
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
  - 7) WEIGHT: 0.6 lbs
  - 8) TOOLING: THERMOFORM PER MOLD DT9073 PER DART QSI 022. TRIM PER MOLD.
  - 9) MINIMUM THICKNESS: 0.040" UNLESS OTHERWISE NOTED

PART NUMBER	DESCRIPTION
D3828-1KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3828-1KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

A	NEW ISSUE	PH	09.06.12
REV.	DESCRIPTION	BY	DATE
DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. 1
MFG. APPR.		D3828	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		VERTICAL TUNNEL (206 L/L1/L3/L4)	NTS
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A  
AB  
09.07.07



**D3828-1 VERTICAL TUNNEL, LOWER L/H**

**NOTES:**

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
- 7) WEIGHT: 0.6 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9228 PER DART QSI 022. TRIM PER MOLD.
- 9) MINIMUM THICKNESS: 0.050" UNLESS OTHERWISE NOTED

PART NUMBER	DESCRIPTION
D3828-1KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3828-1KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

A	NEW ISSUE	PH	09.06.12
REV.	DESCRIPTION	BY	DATE
DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3828	SHEET 1 OF 2
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DE APPR.		VERTICAL TUNNEL (206 L/L1/L3/L4)	NTS
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